

Thursday, 16/08/2007 3:09:51 PM  
Linda Lacelle

## Process Sheet

Order Number	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L FWD X-TUBE
Part Number	: 34039	Part Number	: D206667103
Material Number	: 10553	Drawing Number	: D206-667-143 REV B
Rev. Number	:	Project Number	: N/A
This Issue	: 16/08/2007 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: 16/08/2007 Type : LANDING GEAR	Due Date	: 05/09/2007
Previous Run	: 34038	Qty:	1 Um: Each
Written By	:		
Checked & Approved By	:		
Comment	: Est Rev: F 05/09/01 Add holes for compatibility with Bell Skid tubes KJ/JLM		

## Additional Product

Job Number:



*Handwritten signature*

Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG002

2.0 D6002115 Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6002-115 Crosstube B2943

Check OD = 2.250"; ID = 1.750"

*Handwritten signature*

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA087

2-Turn first side as per Folio FA087

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

*Handwritten signature*

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

*Handwritten signature*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 3:09:51 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 34039

Part Number: D206667103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA087

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143

Inside of Cuff(Donot engrave on outside of tube)

88 07/08/22

6.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

88 07/08/22

7.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

88 07-08-22 (1)

8.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

JD 7-9-5

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

7-9-5

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7-9-5

11.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE


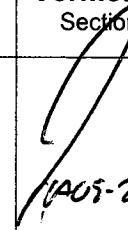
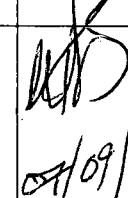
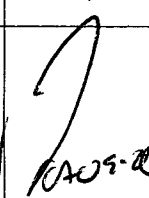
Bend tube as per Dwg D206-667-143 using CNC bender program 206L-fw and Folio FT017

PTC  
EL 7-9-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0709-10	11.0	Too far extremely over bent on one side. Only one side bent. Auto program R.C. Machine wasn't reset correctly.	 07/09/24	Scrap; destroy. Cut to be on the outside of the bends.	E.L. 07-09-10	 07-09-24	 07/09/24	 0709-10

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 3:09:51 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 34039

Part Number: D206667103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143 Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-143.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Drawing Name: 206L FWD X-TUBE

Job Number: 34039

Part Number: D206667103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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17.0	OUTSIDE SERV.10	OUTSIDE SERVICES -LG
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**Comment:** Sub-Contracting OUTSIDE SERVICES  
Liquid Penetrant Inspection as per QSI 038Or  
Issue P/O: \_\_\_\_\_ LPI as per ASTM 1417  
Level 2 Attach copy of NDT results to work order

18.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
Inspect for transit damage  
Ensure copy of NDT results attached to work order.

19.0	QC6	DIMENSIONAL CHECK
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**Comment:** Inspect for damage & ensure results are as per Dwg D206-667-103

20.0	SPRAY PAINTING	SPRAY PAINTING
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**Comment:** SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

21.0	QC14	INSPECT SPRAY PAINT
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**Comment:** Inspect Spray Paint  
Wrap in plastic bag to protect from scratches

22.0	D2856400	Abrasion Strip
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**Comment:** Qty.: 1.2138 f(s)/Unit Total : 1.2138 f(s)  
Pick:  
Qty Part number Description Batch  
2 D2856-400(Cut to 6.94") Abrasion Strip \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Thursday, 16/08/2007 3:09:52 PM

User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 34039

Part Number: D206667103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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23.0	D2873043	Nut Plate Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate \_\_\_\_\_

24.0	D2873045	Nut Plate Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate \_\_\_\_\_

25.0	D28911	Support 2.25 dia
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1 Support \_\_\_\_\_

26.0	MS20601AD4W8	RIVET
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Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet \_\_\_\_\_

27.0	MS2192020	Clamp (per MIL-DTL-8783C)
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20 Clamp \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 34039

Part Number: D206667103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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28.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. Note: (2) Aft holes should be facing up.

2-Install supports and clamps as per Dwg D4206-667-143. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

29.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

30.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0	AN532A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: \_\_\_\_\_

32.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: \_\_\_\_\_

33.0	AN57A	Bolt
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty	Part number	Description	Batch
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10	AN5-7A	Bolt	_____
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 3:09:52 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 34039

Part Number: D206667103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0	AN530A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

4 AN5-30A Bolt \_\_\_\_\_

35.0	AN960JD516	Washer
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Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

18 AN960JD516 Washer \_\_\_\_\_

36.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

37.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

38.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 07.09.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-143	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH FWD)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

05.07.26 HDS

**UNDER REVIEW**

05.07.10 PH  
re-draw detail F

Qty	Part Number	Description
X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
1	D6002-115	CROSSTUBE
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

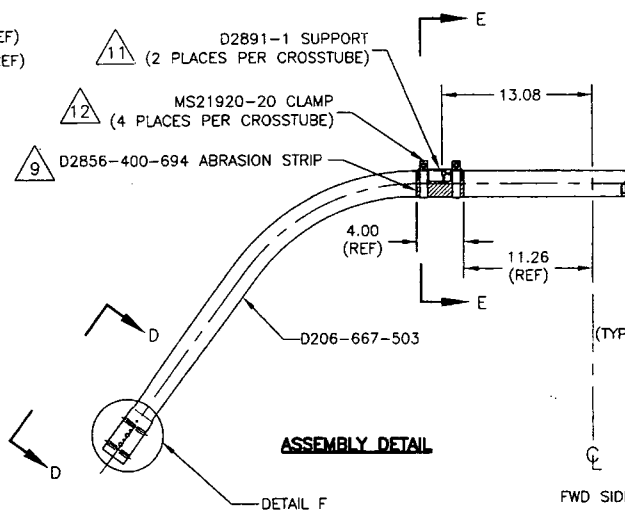
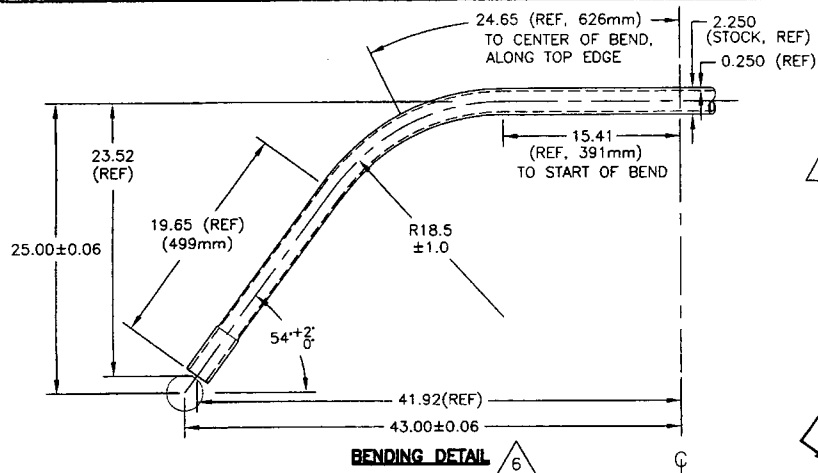
#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6002-115  
FINISHED LENGTH = 104.98±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

w/o 34039

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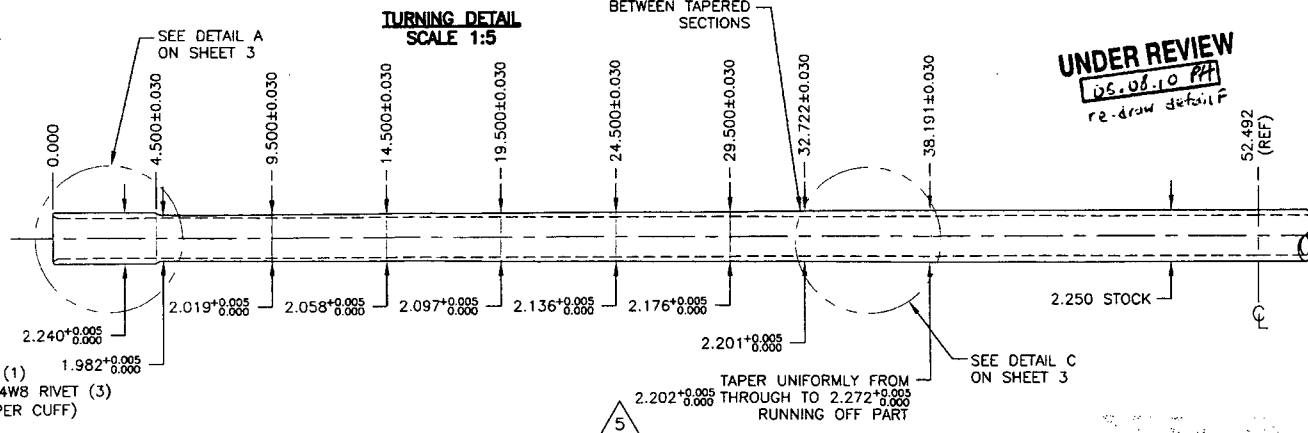
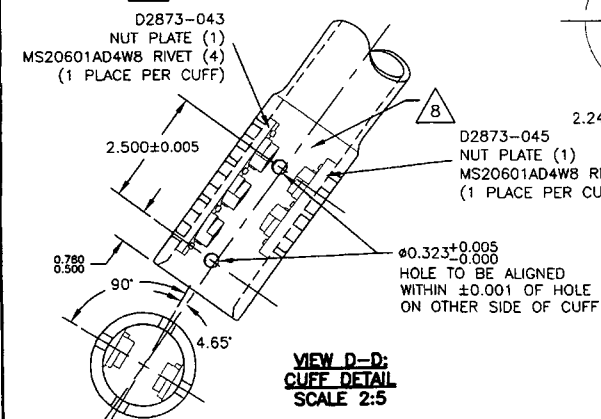
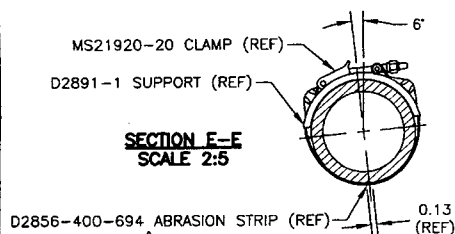


△ B  $\phi 0.323^{+0.005}_{-0.000}$   
(TYP 5 PLACES PER CUFF)  
HOLE TO BE ALIGNED WITHIN  $\pm 0.001$  OF HOLE ON OTHER SIDE OF CUFF

PILOT  $\phi 0.128$   
C'SINK  $\phi 0.225 \times 100'$   
(TYP 7 PLACES PER CUFF)

FWD SIDE ONLY

**DETAIL F**  
SCALE 2:5



**UNDER REVIEW**  
05.08.10 PH  
re-draw detail F

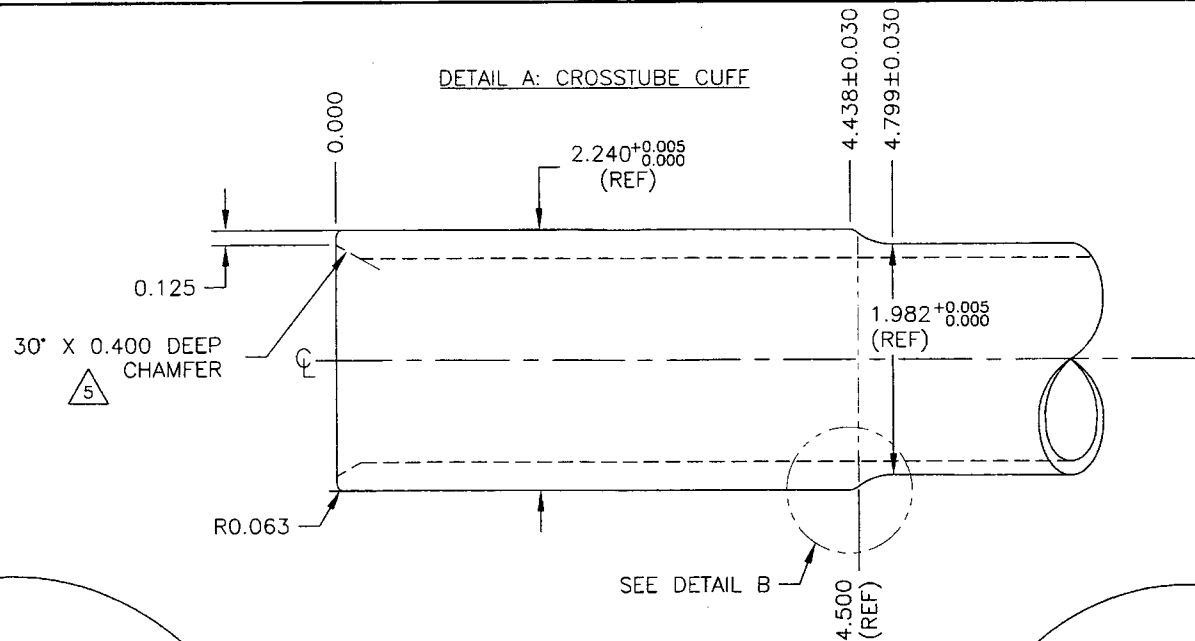
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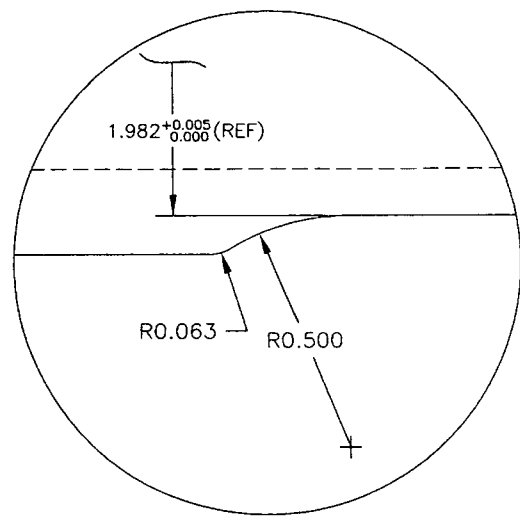
DESIGN PH	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D206-667-143	REV. B SHEET 2 OF 3
DATE 05.07.26	TITLE CROSSTUBE ASS'Y (206L HIGH FWD)	SCALE 1:10	



# DETAIL A: CROSSTUBE CUFF

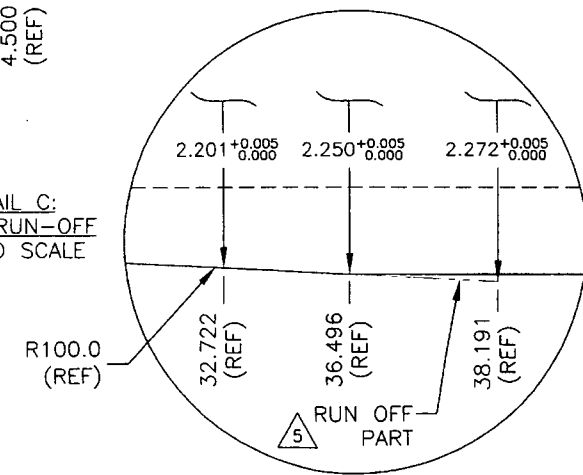


05.07.26 #  
**UNDER REVIEW**  
 05.08.10 PH  
 re-draw detail F



DETAIL B: CUFF  
 TRANSITION  
 SCALE 4:1

DETAIL C:  
 TAPER RUN-OFF  
 NOT TO SCALE



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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. B
		DATE	05.07.26			D206-667-143	SHEET 3 OF 3
		TITLE	CROSSTUBE ASS'Y (206L HIGH FWD)				SCALE 1:1

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 34039
<b>Description:</b> Crosstube Assembly (206L High Fwd)	<b>Part Number:</b> D206-667-143
<b>Inspection Dwg:</b> D206-667-143 <b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.245	✓			
	1.982	+0.005/-0.000	1.987	✓			
	2.019	+0.005/-0.000	2.024	✓			
	2.058	+0.005/-0.000	2.064	✓			
	2.097	+0.005/-0.000	2.102	✓			
	2.136	+0.005/-0.000	2.141	✓			
	2.176	+0.005/-0.000	2.181	✓			
	2.201	+0.005/-0.000	2.206	✓			
	0.125	+/-0.010	.125	✓			
	0.400 x 30°	+/-0.010	.400	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.438	+/-0.030	4.438	✓			
SIDE B	104.98	+/-0.020	104.98	✓			
	2.240	+0.005/-0.000	2.245	✓			
	1.982	+0.005/-0.000	1.987	✓			
	2.019	+0.005/-0.000	2.024	✓			
	2.058	+0.005/-0.000	2.064	✓			
	2.097	+0.005/-0.000	2.102	✓			
	2.136	+0.005/-0.000	2.141	✓			
	2.176	+0.005/-0.000	2.181	✓			
	2.201	+0.005/-0.000	2.206	✓			
	0.125	+/-0.010	.125	✓			
	0.400 x 30°	+/-0.010	.400	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.438	+/-0.030	4.438	✓			

<b>Measured by:</b> S.B.	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/01/22	<b>Date:</b> 07-08-22	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue (P/O D206-667-103)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

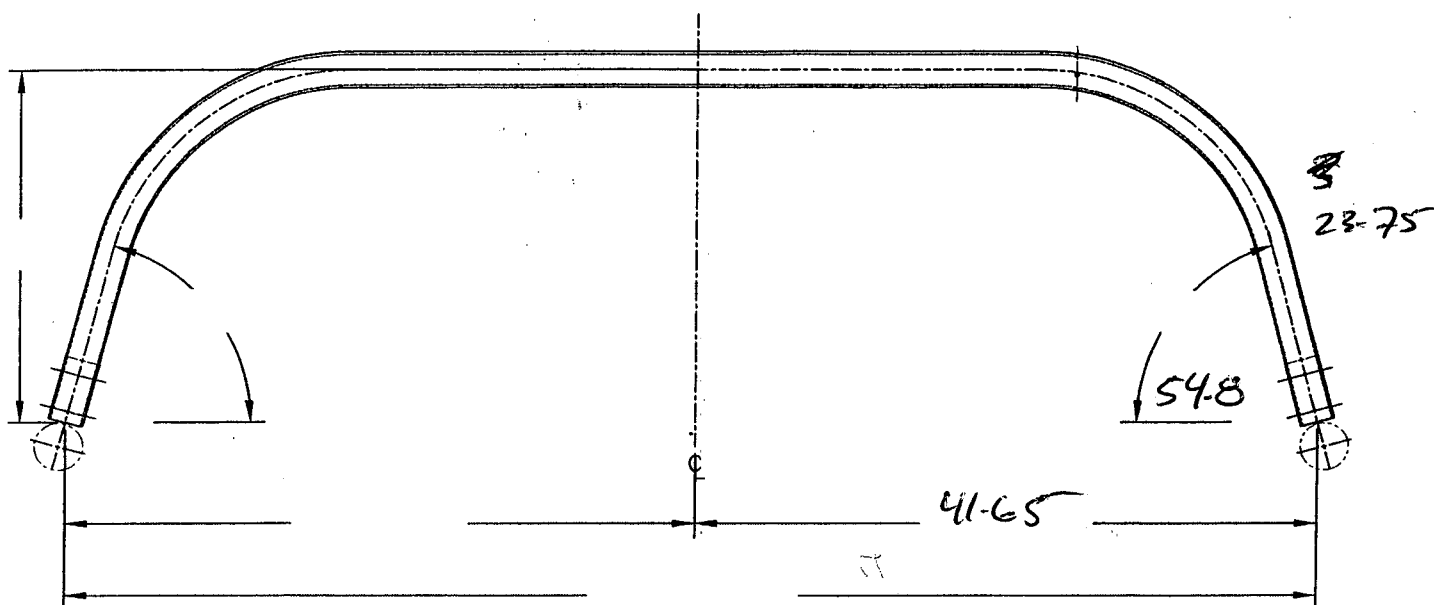
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 34039
<b>Description:</b> Crosstube High Fwd (206L)		<b>Part Number:</b> D206-667-103
<b>Inspection Dwg:</b> D206-667-143 <b>Rev:</b> B		<b>Page 1 of 1</b>

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries